

Date: Friday, 10/20/2006 11:05:50 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 29082A03		
Estimate Number	: 10145		
P.O. Number	: <i>N/A</i>	Part Number	: D2037101
This Issue	: 10/20/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2037 REV C3
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL/MED FAB	Drawing Revision	: C3
Previous Run	: 28237	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/27/2006
Checked & Approved By	: <i>[Signature]</i> 06 10 20	Qty:	<i>10</i> Um: Each
Comment	: Est Rev:A New Issue 05-11-01 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 4.1118 f(s)/Unit Total : 20.5590 f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049)
 Batch: *M 102502*

FF 06-11-01 10

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1

FF 06-11-01 10

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037

2-Flatten ends of D2037-101 tube as required using DT8545

3-Deburr as required

FF 06-11-07 10

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WS*

PD 06-11-10 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 06/11/10

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 10/20/2006 11:05:50 AM
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Drawing Name: ARM

Job Number: 29082A03

Part Number: D2037101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

206/11/10

Job Completion



c 206/11/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

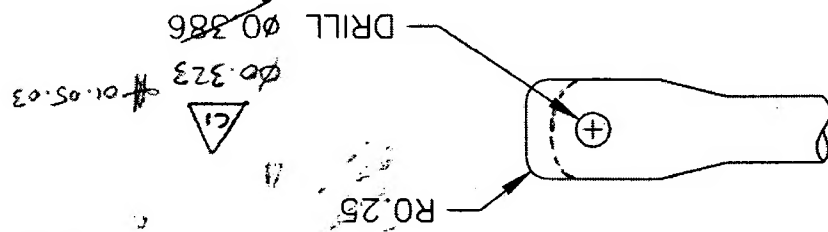
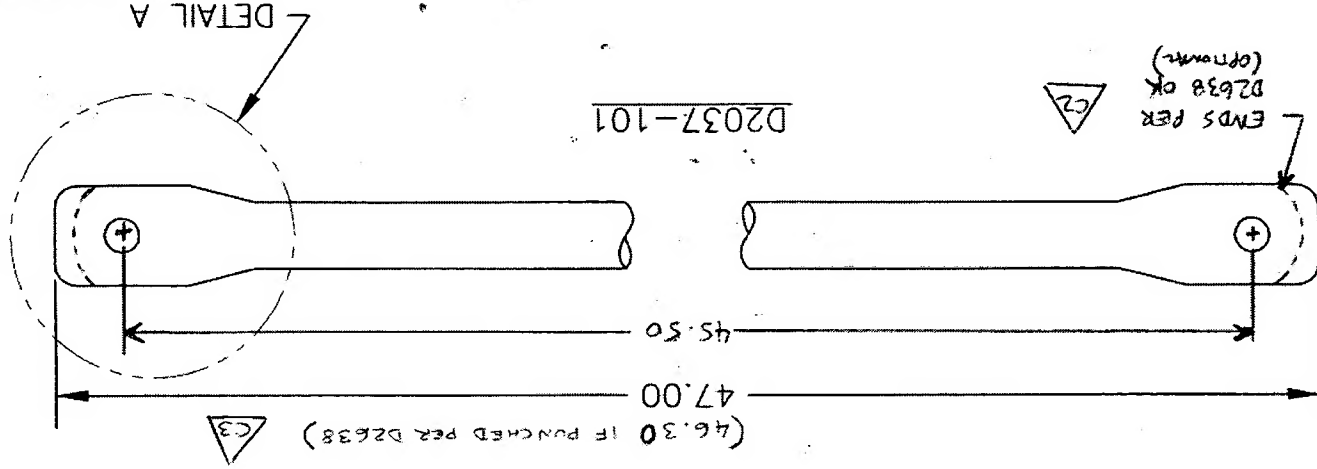
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

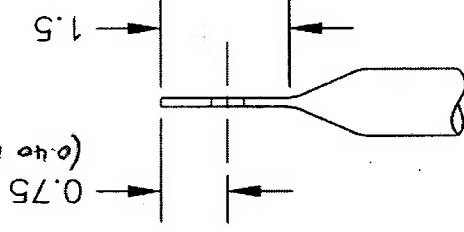
DART



DESIGN	DRAWN BY		DART AEROSPACE LTD	
JB	RF		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C	
LE		D2037	SHEET 1 OF 1	
DATE	TITLE		SCALE	
99.06.07	ARM		NTS	
A	91.10.22	NEW ISSUE		
B	93.04.20	-103 DELETED		
C	99.06.07	REDRAWN, 0.386 WAS 0.375		
C1	01.05.03	CHANGE TO $\phi 0.323$		
C2	02.06.14	ADD PUNCH PER D2638 AS OPTION		



(0.40 IF PUNCHED PER D2638)



RELEASED
RE 99.06.10

MATERIAL: AISI 304/316 SS SEAMLESS TUBE, 0.750 O.D. x 0.049 WALL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 26082A03

C3 05.04.27 ADD 46.30 PUNCHED PER D2638

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries